Dart Aerospace Ltd. Wednesday, 10/11/2006 11:11:34 AM Kim Johnston User: **Process Sheet** : LUG BRACKET **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 28917 : 10009 **Estimate Number** : NIA : D27351 Part Number P.O. Number S.O: No. : NIA : D2735 REV C **Drawing Number** : 10/11/2006 This Issue : N/A Project Number : NC. Prsht Rev. : NIA : C : SMALL /MED FAB **Drawing Revision** Type First Issue : Wisa : 28646 Material **Previous Run** : 10/26/2006 40 Um: Each Qty: **Due Date** Written By Checked & Approved By Removed from 9 Digit 05-10-25 JLM Comment : Est Rev:C ( EC est rev D 06.09.19 waterjet **Additional Product** Job Number: Description: Seq. #: 1.0 M1010S125 1010-1025 sheet .125 0.1733 sf(s)/Unit Total: 6.9300 sf(s) Comment: Qty.: 1010-1025 sheet .125 batch: M 102247 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2735 (D2735-1) Dwg Rev: C Prog Rev:\_\_\_\_\_ OF : 10 : 23
INSPECT PARTS AS THEY COME OFF MACHINE 2-Deburr if necessary 3.0 QC2 Comment: INSPEC PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK BRAKE NC 06/1/2104 Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.

### Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CHA	CEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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			<i>:</i>									
Part No:		PAR #:	Fault Category:			NCR: Yes (No) DQA: Date: Obliblob						
						QA: N/C	Closed:	Date: _				
NCR:			WORK ORD	ER NON-CONFORI	MANCE	(NCR)						
DATE	CTED	Description of NC	Corrective Action Section E			Verification   Annrol		Approval	al Approval			
DATE	STEP	Section A	Initial Chief Eng			Sign & Date	Section C	Chief Eng	QC Inspector			
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NOTE: D	ate & initia	al all entries	1				<u> </u>	<del></del>	1			

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Wednesday, 10/11/2006 11:11:35 AM Date: Usera Kim Johnston **Process Sheet Drawing Name: LUG BRACKET** Customer: CU-DAR001 Dart Helicopters Services Job Number: 28917 Part Number: D27351 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5

Comment: INSPECT WORK TO CURRENT STEP

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: <u>WS</u>23

8.0 QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

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Job Completion



C/06/12/06

PACKAGING RESOURCE #1

CP(06.12.06

#### **Dart Aerospace Ltd**

W/O:			WC	RK ORDER CHANG	GES						
DATE STEP		PROCEDURE CHANGE			Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			•								
Dord No.	-	DAD #.	FW O-4	,	NOD Y						
Part No	) i	PAK#:	AR #: Fault Category:				NCR: Yes No DQA: D QA: N/C Closed: D				
NCR:			WORK ORDE	ER NON-CONFORM				u	_ Date		
			Corrective Action Co.			Sign & Section C					
DATE	STEP	STEP Description of NC Section A		Initial Action Description Chief Eng Chief Eng				on C	Approval Chief Eng	Approval QC Inspector	
						,					

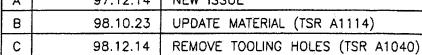
NOTE: Date & initial all entries

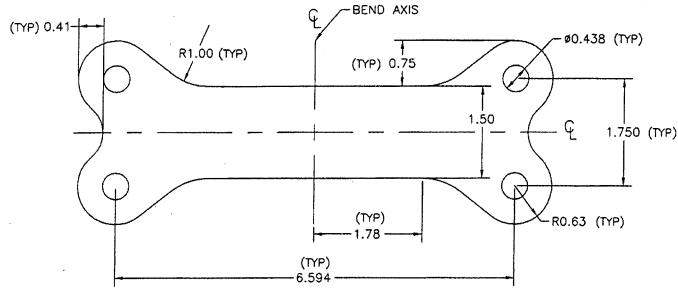




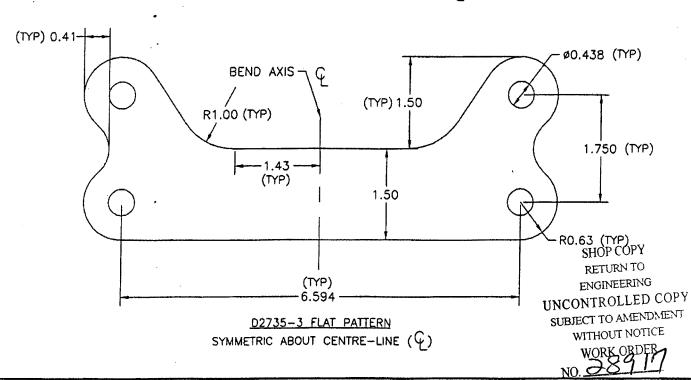
DESIG	<b>H</b>	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECI	P	APPROVED KE	DRAWING NO. REV. C D2735 SHEET 1 OF 2
DATE	•		TITLE SCALF.
98.1	2.14		LUG BRACKET 2:3
Α		97.12.14	NEW ISSUE
R		98 10 23	LIPDATE MATERIAL (TSR A1114)

# RELEASED



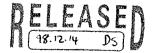


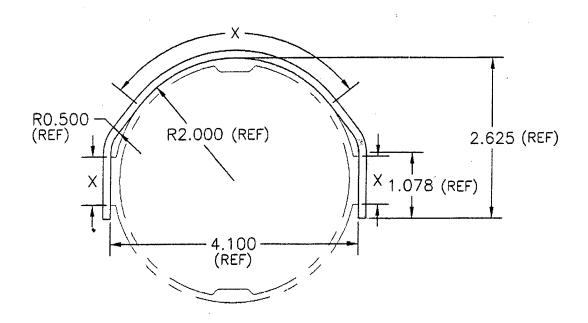
## $\begin{array}{c} \underline{\text{D2735-1}} \ \ \text{FLAT} \ \ \text{PATTERN} \\ \text{SYMMETRIC} \ \ \text{ABOUT} \ \ \text{BOTH} \ \ \text{CENTRE-LINES} \ \ ( \begin{matrix} \varphi \\ \end{matrix} ) \end{array}$





DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAI	
СНЕСКЕЙ	APPROVED #E	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	2:3





D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL

0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi MIN. YIELD TENSILE STRENGTH = 28 ksi

SHOP COPY

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

RETURN TO ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

DART AEROSPACE LTD	Work Order: 28917
Description: Lug Bracket	Part Number: D2735-1
	71
Inspection Dwg: D2135 \ Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	x Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006-0.001	0.438	1		Vern	• •
1.50	+1-0.030	1.50	1		vern	
1.750	+1-0.010	1.750	<b>√</b>		verN	
6.594	41-0.010	6.597	<b>V</b>		YEAN	
0.41	+1-0.030	0.40	. ✓		Vern	
0.15	+1-0.030	0.76	<u> </u>		VerN	
RO.63	+1-0.030	RO.63	1		RAdius Gur	GL
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Measured by:	Audited by:		Prototype Approval:	-
Date: 06 10 19	Date: 0	6.10.20	Date:	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	L